

ASAX

Work Order ID 77710

77710

Item ID: D6202 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: I-Beam Extrusion
Start Date: 19/12/2011 Start Qty: 20.00 *20* Cust Item ID:
Required Date: 02/01/2012 Req'd Qty: 20.00 *20* Customer:
Reference:

Approvals: Process Plan: M.L.J. Date: 11/12/19 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D6202	Rev A								

100 PURCHASING 0.00
100
Purchasing Memo 0.00
Purchasing Issue P/O: 15788 a) Description: American standard I-beam 4.000" x 2.796" x 0.326" thick b) Material: 6061-T6/T651 (QQ-A-200/8) c) Minimum ultimate tensile strength = 38 ksi d) Minimum yield tensile strength = 35 ksi

CL 12/11/04 25

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
Packaging Memo 0.00
Packaging Ensure material certification is attached

44/01/16 25

120 QC6- Inspect dimensions to drawing 0.00
120
QC Memo 0.00
Quality Control Ensure Material certification comply to Dwg D6202

12/01/16

25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77710

77710

Page 2

December-19-11 8:21:16 AM

Item ID: D6202

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: I-Beam Extrusion

Start Date: 19/12/2011 Start Qty: 20.00

20

Cust Item ID:

Required Date: 02/01/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: MAT 28 0.00

12/01/16

130

Packaging

Memo

0.00

25

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/1/16
mf
12-01-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

December-19-11 8:21:20 AM

Page 1

Work Order ID: 77710

77710

Parent Item: D6202

D6202

Parent Item Name: I-Beam Extrusion

Start Date: 19/12/2011

Required Date: 02/01/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A: 01.04.19New Issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6202P		Purchased	No			110	f	0.0000	1	20			
D6202P									**				
I Beam Extrusion													

Signature
12/01/16 (25)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

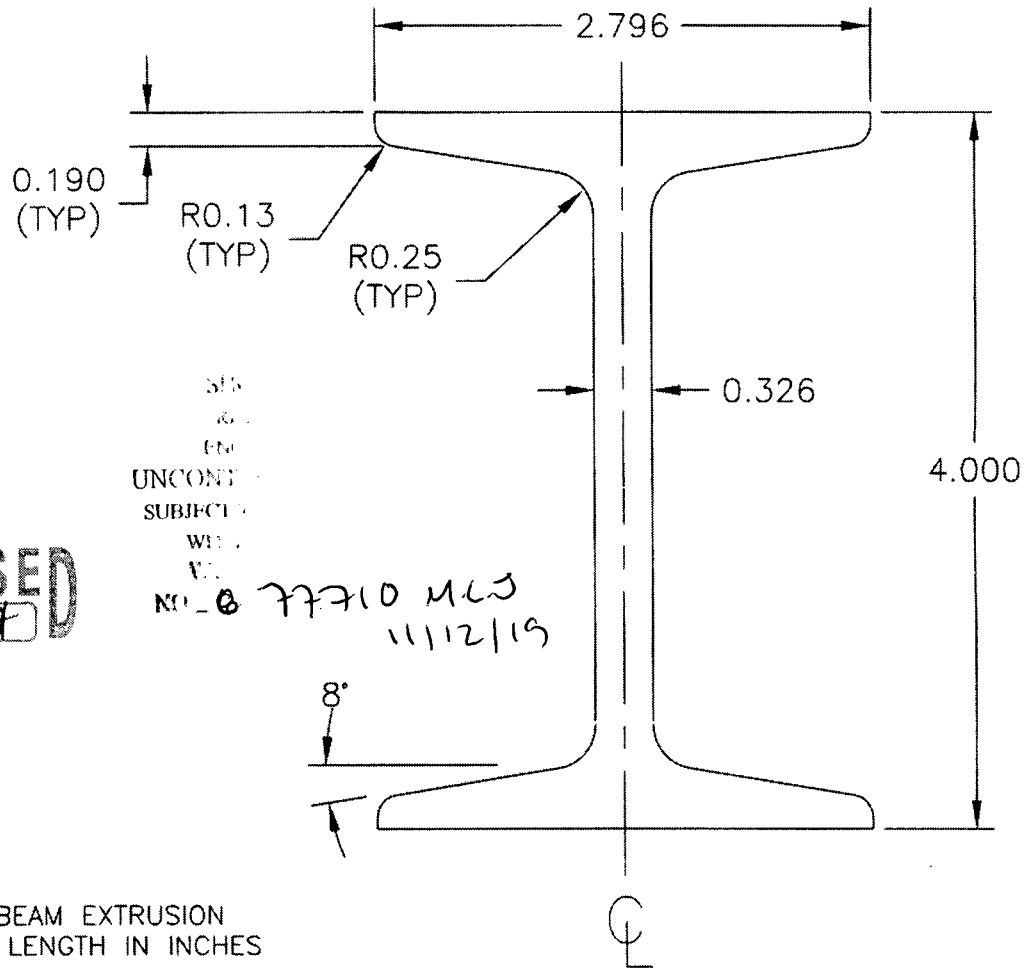
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D6202	REV. A SHEET 1 OF 1
DATE 01.04.02		TITLE I-BEAM EXTRUSION	SCALE 1:1
A	01.04.02	NEW ISSUE	

SPECIFICATION CONTROL DRAWING



D6202-XXX I-BEAM EXTRUSION
WHERE XXX IS LENGTH IN INCHES

EG.
D6202-027 IS 27 INCHES LONG

PURCHASE MATERIAL: AMERICAN STD. I-BEAM
4.000" x 2.796" x 0.326" THICK
6061-T6/T651 (QQ-A-200/8)
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM YIELD TENSILE STRENGTH = 35 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO15788

Purchase Order Date 1/04/12

PO Print Date 1/04/12

Page Number 1 of 2

Order From :

VC-MAG002

MAGNA STAINLESS
5775 RUE KIERAN
ST LAURENT, QC H4S 0A3
CA

Contact Name

Vendor Phone

800 363 6646

Vendor Fax

514 339 1105

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D6202P	1 Beam Extrusion	1/13/12 Yes	25.00 f	Yours ppd	\$29.5600	\$739.00
		Special Inst: AS PER DWG D6202 REV. A B77710 MATERIAL: 6061-T6/T651 AS PER QQ-A- 200/8 MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI MINIMUM YIELD TENSILE STRENGTH = 35 KSI					
2	M304R1.500	304 round bar 1.500	1/13/12 Yes	24.00 f	Yours ppd	\$14.5800	\$349.92
		Special Inst: MATERIAL: AISI 304/316 SS ROUND BAR AS PER ASTM A276 NOTE: AISI 303 NOT ACCEPTABLE					
3	M303R0.750	303 Round Bar 0.750	1/13/12 Yes	60.00 f	Yours ppd	\$3.9583	\$237.50

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

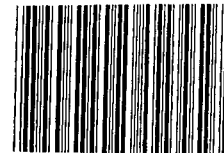
Change Nbr: 1

Change Date: 1/04/12



Magna Stainless

5775 Kieran St, Saint-Laurent, Quebec H4S 0A3
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105



I053910

PACKING LIST

Page 1 of 1

I053910

SOLD TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7

SHIP TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7

SPECIAL INSTRUCTIONS

***INC 17479

Contact: C.LAVOIE

Ship Terms: PREPAID

MTR:C

Currency		Sales Person	Customer Phone	Customer Fax	Customer PO	
CANADIAN DOLLARS		CHRISTINA ANTONIOU	(613) 632-5200	(613) 632-1053	P015788	
Sales Order	Terms	Ship Via		Date Ordered	Date Required	Date Shipped
W059617	NET 30 DAYS	NIR:R-557065-1		01/06/12	01/16/12	01/16/12

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
1		PC	ALUMINUM - PCS 6061 T6 AS IB 4.00 X 2.80 X .326 X 25' LG MATERIAL IS I BEAM MILL TEST REQUIRED WITH DELIVERY	L057940	201116354	1 1
Pieces: 1				Approx Weight:		85 LB

Received by: _____ Date: _____ Signature: _____



SERVICE CENTER METALS
5850 Quality Way
Prince George, VA 23875

11414 046037

CERTIFIED INSPECTION REPORT AND TEST RESULTS FOR EXTRUDED PRODUCTS

Quantity Certified 2,218 lbs 27 pcs

MANIFEST NUMBER 143384
CUSTOMER PO P11010CG037 CT
CUSTOMER PART NUMBER BS0291

DIE NUMBER BS0291
ALLOY/TEMPER 6061-T6
DESCRIPTION ASI 4.000x2.796x.326

DATE OF SHIPMENT 10/27/2011
SALESPERSON David Schroeder

OUR ORDER NUMBER	ITEM
137007	1

CERTIFICATION
ASTM-B308-10 SPOT STENCIL

SPECIFICATION
ASTM-B221-08

SPECIFICATION
AMS-QQA-200/8

SPECIFICATION
AMS-QQA-200/16

We hereby certify that the material covered by this report has been inspected in accordance with the most recent certification revision, and has been found to meet the applicable requirements described herein, including any specifications forming a part of the description, and that samples representative of the material met the composition limits and had the mechanical properties shown. SCM extrusions are manufactured in the USA from ingot melted and cast in the United States or Canada.

Mechanical Properties

Tests	Lot No.	Test Date	Ultimate Tensile Strength (KSI)	Yield Strength (KSI)	Percent Elongation
1	201110354	10/26/11	40.9	35.8	11.0
2	201116354	10/26/11	41.4	36.0	13.3

Chemical Composition for Aluminum Alloy 6061

Cast Number	Alloy	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Others	Total	Melted In
C71S0317	6061	0.73	0.18	0.33	0.09	0.91	0.09	0.01	0.02	0.05	0.15	United States of America

Calvin J. Wiggins
Calvin J. Wiggins, Director of Quality & Technical Services

Print Date: 10/27/2011

Rev. 9/23/11 - QMS

ISS 01-12-12

520109FH001-1 MAGNA STAINLESS PO: 6017479 Page 4: 1.00EC

**MAGNA INOXYDABLE
INC.**

5775 RUE KIERAN
ST-LAURENT, QUEBEC
H4S 0A3 (514) 339-1211, 1-800-363-6646

**CERTIFICAT DE CONFORMITE
CERTIFICATE OF CONFORMANCE**

DATE: January 13, 2012

**COMPAGNIE / DART AEROSPACE
COMPANY:
ATTENTION:**

VOTRE/YOUR #: P015788

**DATE DE LA COMMANDE / 01/06/12
ORDER DATE:**

NOTRE / OUR #: I053910

<u>DESCRIPTION</u>		<u>QUANTITE/QUANTITY</u>	<u>SPECIFICATIONS</u>
TYPE:	6061 T6	1 PC	ASTM B221-08
SIZE:	4.00 X 2.80 X .326 X 25' LG		
HEAT #:	201116354		

MILL SOURCE: SERVICE CENTER METALS

Magna Stainless certifie que le matériel décrit ci-dessus, s'accorde aux dessins ou aux spécifications demandées sur le bon de commande et qui sont en vigueur à la date ou la commande est acceptée.

Magna Stainless certifies that the material described above is in accordance with the drawing or specifications called for on said order that is current on the date order was accepted.

**MAGNA
MTR #: L053910**

Signed: B. M. [Signature]

